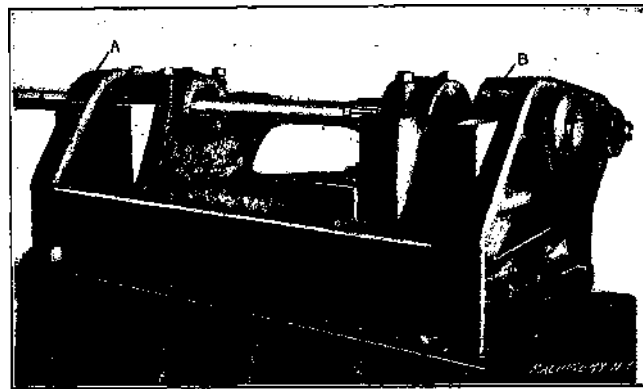


blocks are located exactly as the tailstock itself, so that the work placed on them will come in the same relative position to the uprights of the jig whether the work rests directly on the jig bottom or on the raising pieces. The two finished strips *F* are provided for facilitating the making of the jig, and the lugs *G* for the clamping down of the jig to the boring machine. The jig, however, can also be clamped to the boring machine table as shown in the illustration. At *H* is a liberal clearance between the work and jig, allowing ample room for the inserting of facing cutters, reamers, and boring tools. Ribs are provided for strengthening the jig, as shown.



**Fig. 10. Large-size Boring Jig made from a Solid Casting**

Fig. 10 shows a large-size boring jig made from a solid casting. In this case the work to be bored out is the head of a lathe. It is located and clamped to the jig in a way similar to that mentioned in the case of the tailstock; clamping it to the jig in the same way that it is fastened to the lathe bed insures that the effects of possible spring will be less noticeable. Opinions differ as to whether it is good practice to make up a jig of the size shown in one piece, the distance between the standards *A* and *B* being from four to five feet, or whether it would be better to make loose members located on a baseplate. With loose members there is no assurance that the standards are located correctly in relation to each other or to the work